

4/27

[Dart Hawkesbury] Job Sheet - David, Logan

(6)



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

RBT18591-5
Job Sheet 176656



Part No: RBT18591-5

Job Qty: 4 ea

Part Name: Puller Rod



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 4/27/18

Job Tracking No:

Due Date: 5/7/18

Created By: Logan David

Type: Stock

Description:

Note: DWG RBT18591 Rev 2B IPP Rev A 18.02.28 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	5/7/18	5/7/18	0.00	0.00	Start Up Machining-3		DL 18-5-7
100	CNC Lathe	4 pcs	5/7/18	5/7/18	0.00	0.80	MORI SL-154		JK
105	QC	4 pcs	5/7/18	5/7/18	0.00	0.00	QC2 Machining-2		JK
130	QC	4 pcs	5/7/18	5/7/18	0.00	0.00	QC8 Machining-4		JK
150	Outsource	4 pcs	5/7/18	5/7/18	0.00	0.00	Outsource1		JK
155	Outsource	4 pcs	5/7/18	5/7/18	0.00	0.00	Outsource12		JK
160	Packaging	4 pcs	5/7/18	5/7/18	0.00	0.00	Packaging2		JK
170	QC	4 pcs	5/7/18	5/7/18	0.00	0.00	QC6		JK
180	Packaging	4 pcs	5/7/18	5/7/18	0.00	0.00	Packaging3-1		JK
190	QC21-SA	4 Ea	5/7/18	5/7/18	0.00	0.00	QC21		JK

Part Op 100 - 1-Machine as per DWG. FB976 FOLIO REV:

DWG REV:

2-PASS DIE BY HAND TO

Descriptions: CLEAN BURRS 3-Deburr

150 - 1-Issue P/O to Metcore; P/O 035802 RC 32-42 2-Bead blast 3- Certificate of Conformity is required

NOTE DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech***

155 - -Issue P/O to Groupe Altech; PO 0359162 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of

Conformity is required

160 - C of C is required.

POSITIVE RECALL

EFFECTIVE 18/5/18

AUTH

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90322A199	Threaded Rod	1.6800 Ea (42 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	90322A199	6	6	0

SOS/500 5.0

=4 ✓

✓

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 4/27/18 8:07 AM dart.logan.david

Container No: S068776



Part: RBT18591-5

Job No: 176656

Serial No/Batch: S068776

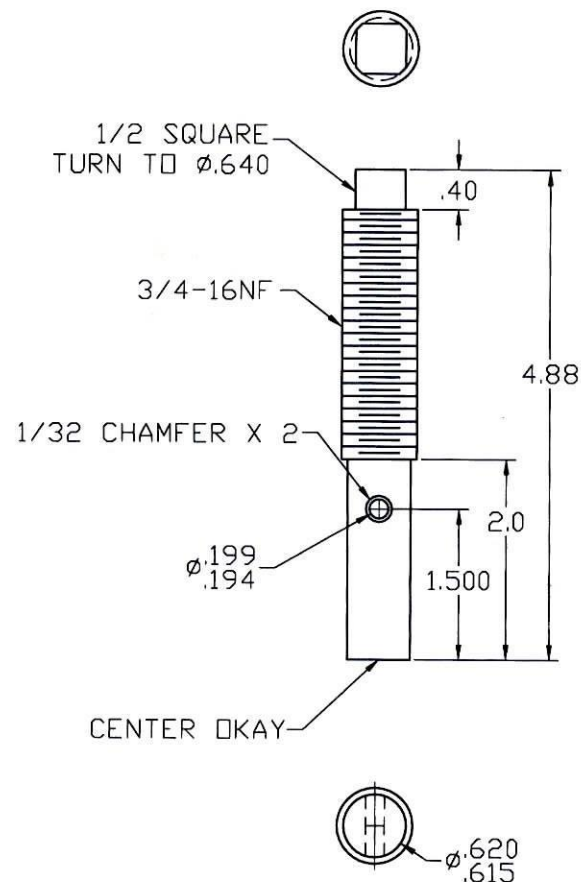
Revision: 2B

Inspector:

Date: 05/07/18

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D -5 BOTTOM TOLERANCE FROM $\phi.625$ TO $\phi.615$.	3/26/08	WP	GE



PULLER ROD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 1766567L
20180427

RED BARN MACHINE	
TITLE BEARING PULLER - FIXTURE	
DWG NO. RBT18591-5	REV 2B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: COLE
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 ANGLES ± .5°	APPROVED: <i>D. West</i> RC 32-42 BLACK OXIDE
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 X 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL: BELL 212 SEE NOTE #1
SCALE NTS	DATE 1/25/02 SHEET 4 of 7

RBT18591-5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039833

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO039833
PO Date: 5/8/18
Due Date: 5/24/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	176875	C2-3-3	Latch Roller 1-Issue P/O to Atlantic Heat Treat; P/O _____ RC 53-56 2-Bead blast 3- Certificate of Conformity is required -Material:4140	Received	5/18/18	20 pcs	20 pcs	0 pcs	\$3.65/pcs	\$0.00
2	175633	C3-3-4	Link Pin 1-Issue P/O to Atlantic Heat Treat; P/O _____ RC 53-56 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Atlantic Heat Treat to ship directly to Groupe Altech*** Material: Drill Rod	Received	5/23/18	30 pcs	30 pcs	0 pcs	\$2.43333/pcs	\$0.00
3	176725	C10-8	Trunnion Bushing 1-Issue P/O to Atlantic Heat Treat; P/O _____ RC 37-40 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Atlantic Heat Treat to ship directly to Groupe Altech -Material:4140	Received	5/23/18	20 pcs	20 pcs	0 pcs	\$3.65/pcs	\$0.00

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	173605	RB877206-5-7	Cutter 1-Issue P/O to Atlantic Heat Treat ; P/O _____ RC 50-60 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO GRINDER Atlantic Heat Treat to ship directly to KG grinding. -Material:O1 TOOL STEEL	Received	5/18/18	8 pcs	8 pcs	0 pcs	\$9.125/pcs	\$0.00
5	173659	RBEM625V3006101-1	Base P/O to Atlantic Heat Treat: P/O _____ heat treat to RC28-32, bead blast after heat treat, part made from 4140 H round bar Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Received	5/18/18	7 pcs	7 pcs	0 pcs	\$19.50/pcs	\$0.00
6	173762	RBEM642V4001102-15	Wrench Weldment 1-Issue P/O to Atlantic Heat Treat; P/O _____ RC 46-50 2-Bead blast 3-Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required -Material:4140	Received	5/18/18	4 pcs	4 pcs	0 pcs	\$19.50/pcs	\$0.00
7	176656	RBT18591-5	Puller Rod 1-Issue P/O to Atlantic Heat Treat; P/O _____ RC 32-42 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Atlantic Heat Treat to ship directly to Groupe Altech*** -Material:B7 ALL-THREAD	Received	5/23/18	10 pcs	10 pcs	0 pcs	\$7.30/pcs	\$0.00

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:										\$0.00
Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

Plex 6/20/18 10:57 AM dart.tsimiklis.chrisoula

Certification

Date: 15/05/2018

Entry Date: 15/05/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: po039833

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: s7

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
10	10 pcs material s7 all- thread harden rc32-42 sand blast rbt18591-5 cfc	3

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

Results:

Harden ROCKWE	32.	42.	40. tested as per sampling
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heated to 40rc as per cust requested

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039962**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039962
PO Date: 5/23/18
Due Date: 5/28/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	175728	C45-13-1	Keeper Bushing -Issue P/O to Groupe Altech: P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 - Certificate of Conformity is required	Firmed	5/28/18	21 pcs	0 pcs	21 pcs	\$1.69014085/pcs	\$35.49
2	176725	C10-8	Trunnion Bushing -Issue P/O to Groupe Altech: P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Certificate of Conformity is required	Firmed	5/28/18	20 pcs	0 pcs	20 pcs	\$1.69014085/pcs	\$33.80
3	176656	RBT18591-5	Puller Rod -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	5/28/18	10 pcs	0 pcs	10 pcs	\$12.00/pcs	\$120.00

DAS
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9-89



Certificat de Conformité / Certificate of Compliance

(009594-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

009594 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
25-May-2018		Aman		PO039962				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
2	C10-8 Rev.	C10-8 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS 2 GRADE E OR F 0.0004-0.0006 THICK BAKE AFTER PLATING	E-NICKEL STEEL CH	20	20	0	0	0
3	RBT18591-5 Rev.	RBT18591-5 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	10	10	0	0	0
4	C3-3-4 Rev.	C3-3-4 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS 2 GRADE E OR F 0.0004-0.0006 THICK BAKE AFTER PLATING	E-NICKEL STEEL CH	30	30	0	0	0

 DA
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 1-8

MAY 26 2018

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.